

GREEN

Dart Aerospace Ltd.

Date: Thursday, 4/26/2007 3:33:53 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 32076	
Estimate Number : 10530	
P.O. Number : <u>N/A</u>	Part Number : D2571
This Issue : 4/26/2007 S.O. No. : <u>N/A</u>	Drawing Number : D2571 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 31806	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 5/30/2007 Qty: 10 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 7075-T7351 8.25X7.75X2.5
 Make from D6101-007 billet for D2571
 Ensure that grain is along 7.75" length
 Batch No: B 25353

ml/07/05/28

10

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 32076 Double check by: JL

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

ml/En 07/05/30 (X10)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572

ml/En 07/05/30 (X10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml/En 07/05/30 (X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/05

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

07-05-30

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

07-05-30 (10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat OLIVE DRAB GREEN

(Ref: 4.3.5.1) as per QSI 005 4.3

m/04476

07/06/05 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/06/05 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/06/05 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/05 (10)

Job Completion



07/06/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32076
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.439	0.439	0.438	0.439		
B	1.745	1.755		1.748	1.749	1.749	1.748		
C	3.495	3.505		3.499	3.499	3.500	3.499		
D	1.745	1.755		1.748	1.749	1.749	1.748		
E	7.990	8.010		8.000	8.006	8.004	8.004		
F	0.490	0.510		0.503	0.505	0.503	0.504		
G	0.257	0.262	DT8688	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.501	0.502	0.503	0.502		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.567	0.568	0.568	0.568		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.490	1.500		1.493	1.493	1.493	1.493		
N	2.495	2.505		2.498	2.499	2.499	2.499		
O	3.869	3.879		3.871	3.871	3.871	3.871		
P	0.115	0.135		0.126	0.126	0.127	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.250	0.251	0.250		
S	0.115	0.135		0.136	0.128	0.129	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.243	0.243	0.243	0.244		
W	0.115	0.135		0.121	0.120	0.121	0.121		
X	0.308	0.313		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.761	0.761	0.760		
Z	0.352	0.372		0.365	0.365	0.366	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.629	0.633	0.636		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.255	0.251	0.253	0.252		
AE	1.375	1.395		1.385	1.386	1.387	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.250	0.250	0.253		
AI	2.000	2.020		2.001	2.002	2.003	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	JML
Date:	07/05/28

Audited by:	SA
Date:	07.05.30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32076
Description: Saddle, Fwd Outboard		Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.439	0.440	0.440	0.441		
B	1.745	1.755		1.749	1.749	1.749	1.747		
C	3.495	3.505		3.499	3.500	3.499	3.499		
D	1.745	1.755		1.749	1.745	1.749	1.747		
E	7.990	8.010		8.001	8.001	8.002	8.001		
F	0.490	0.510		0.502	0.500	0.502	0.502		
G	0.257	0.262	DT8683	0.258	0.258	0.260	0.260		
H	0.375	0.380	DT8684	0.376	0.376	0.377	0.377		
I	0.490	0.510		0.502	0.502	0.500	0.502		
J	1.174	1.184		1.177	1.177	1.175	1.175		
K	0.558	0.578		0.568	0.568	0.566	0.566		
L	1.174	1.184		1.177	1.177	1.175	1.175		
M	1.490	1.500		1.493	1.493	1.492	1.494		
N	2.495	2.505		2.499	2.499	2.497	2.496		
O	3.869	3.879		3.871	3.871	3.871	3.870		
P	0.115	0.135		0.126	0.126	0.125	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.250	0.250	0.250		
S	0.115	0.135		0.130	0.130	0.126	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.243	0.243	0.242	0.244		
W	0.115	0.135		0.120	0.120	0.121	0.119		
X	0.308	0.313		0.311	0.311	0.310	0.311		
Y	0.760	0.765		0.760	0.765	0.765	0.765		
Z	0.352	0.372		0.363	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.622	0.622	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.253	0.253	0.246	0.246		
AE	1.375	1.395		1.387	1.385	1.386	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.245	0.245	0.260	0.260		
AH	0.240	0.260		0.251	0.251	0.247	0.248		
AI	2.000	2.020		2.001	2.001	2.000	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	am/ep	Audited by:	SD
Date:	07/05/29	Date:	07.05.30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

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E	7.990	8.010		8.003	8.002				
F	0.490	0.510		0.499	0.499				
G	0.257	0.262	DT8683	0.260	0.260				
H	0.375	0.380	DI8684	0.377	0.377				
I	0.490	0.510		0.504	0.501				
J	1.174	1.184		1.175	1.176				
K	0.558	0.578		0.567	0.564				
L	1.174	1.184		1.175	1.176				
M	1.490	1.500		1.495	1.494				
N	2.495	2.505		2.497	2.497				
O	3.869	3.879		3.872	3.872				
P	0.115	0.135		0.126	0.126				
Q	0.115	0.135		0.135	0.135				
R	0.240	0.260		0.251	0.250				
S	0.115	0.135		0.126	0.123				
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V	0.230	0.250		0.239	0.241				
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AA	0.470	0.530		0.500	0.500				
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AE	1.375	1.395		1.388	1.387				
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AI	2.000	2.020		2.002	2.001				
AJ	0.023	0.043		0.033	0.033				
Accept/Reject									

Measured by:	En
Date:	07/05/30

Audited by:	SA
Date:	07.05.30

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